

Work Order ID 72098

Tuesday, July 19, 2011 10:30:00 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 7/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-07-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580-041

Rev.D DEO-D1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041

CHG004

002

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

BB 1 11/08/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends and remove bending marks

2- Prepare tube for swaging as per QSI 002

x1

11/08/03

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11-8-4

11-8-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

M115778

BE

11/08/04

2-Grind welds on step as per Dwg D2580

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x 17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

WELDED A/R M115778
BE 11/08/04
Grind 11/08/05 Wh.
DL 11/08/08
BE 11/08/08

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8 WLOS 112

(YU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S wlog 112

Pro →

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

IX Ø M-14/08/17

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:45
320 OF
11:15

IX Ø M-14/08/18

M17745

W/O: 72098		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D705-634-041 PAR #: _____ Fault Category: Landing Gear NCR: Yes No DQA: A Date: 11/08/23
(CSKID Tubes)
 Resolution: Re work Disposition: Re work QA: N/C Closed Date: 11/8/23

NCR: 72098		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/6/10	140.1	Found at inspection that the 2nd hole from AFT (SADDLE hole) is not fitting test SADDLE.	CP 11/08/10 CS/042	- Drill out + Remove D2579 AND replace B <u>72672</u>	BE 11/08/11	S 11/08/12	P 11/08/10 CS/042	S 11/08/10
		R.C. hole pulled / cross bolt spacer pulled when welding only 1 side affectors Process.	CP 11/08/10	- Re weld AS per Q52004 A/R <u>MIL5778</u> - Re counter bore + Deburr	BE 11/08/11	S 11/08/12	P 11/08/10	S 11/08/10
		(tooling, w/o, drawings are all good. All Employees are fully trained)						

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 of 11 4/08/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ X1117516Sikaflex expire date: 12/012-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as
per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with

Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ X1117516Sikaflex expire date: 12/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M1183131 6 11 108122

W/O:		WORK ORDER CHANGES					
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Work Order ID 72098

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Revision ID:

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Item Name: Replacement Skidtube

Start Date: 7/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

6/18/11

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

*PPD 72098**11/8/23*

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*11/8/23**MF**11-0823*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Tuesday, July 19, 2011 10:30:07 AM

Page 1

Work Order ID: 72098

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 7/19/2011

Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
 KJ IPP Rev P 10.02.19
 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
 10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4202-1		Manufactured	No			140	Each	443.0000	20	20			
---------	--	--------------	----	--	--	-----	------	----------	----	----	--	--	--



Spacer

Location	Loc Qty	Loc Code
LG002	443	
66929	106	
67129	196	
67308	1	
67430	140	

BE 11/08/04
B 72199 20

D2580-1		Manufactured	No			110	Each	3.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



205 Skidtube bent detail

Location	Loc Qty	Loc Code
LG	2	
71014	2	
ST046	1	
70785	1	

BE 11/08/03
B 72461 1

D2576-3		Manufactured	No			140	Each	44.0000	1	1			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Step (maching detail)

Location	Loc Qty	Loc Code
LG	44	
66156	44	

BE 11/08/04

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 72098

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 7/19/2011

Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured

No

200

Each

39.0000

1

1



Cap



HL 11/08/22

Location

Loc Qty

Loc Code

FP007

39

53791

4

65519

2

65569

33

X1

AN3-5A

Purchased

No

200

Each

1,055.000

2

2



Bolt



HL 11/08/22

Location

Loc Qty

Loc Code

ST350

1055

115371

279

117423

776

X2

AN960JD10L

NAS1149D0332J

Purchased

No

200

Each

0.0000

2

2



Washer

1117087



(X2) HL 11/08/22

ALS7-1032-130

Purchased

No

200

Each

1,075.000

50

50



Insert



HL 11/08/22

Location

Loc Qty

Loc Code

ST282

1075

117717

1075

1118037

X50

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 72098

Parent Item: D205-634-041


Parent Item Name: Replacement Skidtube

Start Date: 7/19/2011

Required Date: 8/5/2011


Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 200 Each 1,552.000 50 50

 BOLT


Location	Loc Qty	Loc Code
ST350	1552	
117313	2	1118628
117688	488	
117795	500	
117872	22	
118012	500	
118112	40	

Handwritten: 11/08/22

AN960C10L NAS1149C0332 Purchased No 200 Each 0.0000 50 50

 washer


Handwritten: 1118304

Handwritten: 11/08/22

D3566-13 Manufactured No 200 Each 21.0000 1 1

 Gasket

Handwritten: 11/08/22

Location	Loc Qty	Loc Code
FP	20	
69281	20	364280
FP014	1	
68341	1	

D3566-5 Manufactured No 200 Each 20.0000 1 1

 Gasket

Handwritten: 11/08/22

Location	Loc Qty	Loc Code
FP015	20	
68961	8	
71601	12	

Handwritten: 11/08/22

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Replacement Skidtube

Start Date: 7/19/2011

Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-1

Manufactured No

200 Each

32.0000

2

2



Gasket



11/08/22

Location

Loc Qty

Loc Code

FP011

30

70769

18

71580

12

FP015

2

68924

2

42

D3564-11

Manufactured No

200 Each

4.0000

1

1



Wearshoe



11/08/22

Location

Loc Qty

Loc Code

FP019

4

67591

4

41

D3564-13

Manufactured No

200 Each

22.0000

1

1



Wearshoe



11/08/22

Location

Loc Qty

Loc Code

FP016

11

69280

11

FP017

11

71594

11

41

D3564-9

Manufactured No

200 Each

9.0000

1

1



Wearshoe



11/08/22

Location

Loc Qty

Loc Code

FP019

9

67590

4

69943

5

41

Tuesday, July 19, 2011 10:30:08 AM

Shop Packet Print

Page 4

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Page 5

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Start Date: 7/19/2011

Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No

200 Each

19.0000 1 1



Wearshoe



all 11/08/22

Location

Loc Qty

Loc Code

FG

2

34806

2

FP019

17

70864

17

D2594-3 Manufactured No

200 Each

780.0000 16 16



O-Ring, 205 Skidtube



all 11/08/22

Location

Loc Qty

Loc Code

FP-A

780

65518

54

66952

726

D2594-1 Manufactured No

200 Each

233.0000 16 16



Plug, 205 Skidtube



all 11/08/22

Location

Loc Qty

Loc Code

FP-A

233

42807

28

67441

7

68943

198

V10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 *[Signature]***DEO ATTACHED
UNDER REVIEW***[Signature]*
RMV 11.06.70

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *72098***GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

CP 11.06.30
RMV CP 11.06.30

D2580-1 DRILLING DETAIL

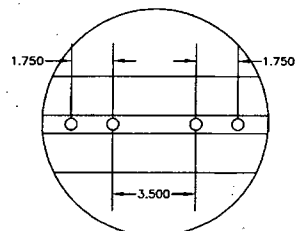


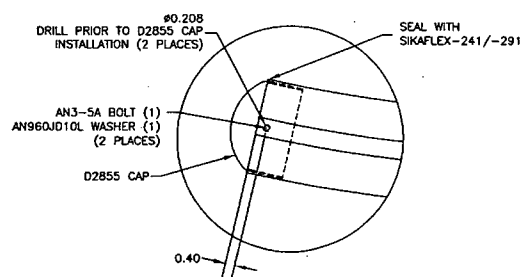
Diagram illustrating the grinding locations for a propeller cross-section. The diagram shows a cross-section of a propeller with the following labeled areas:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

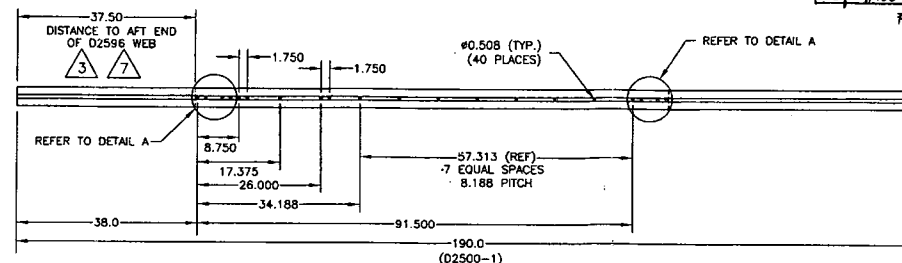
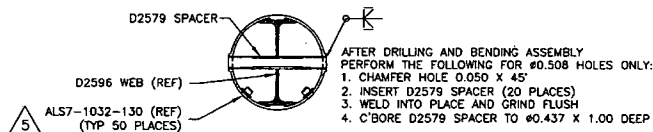
RELEASED
07-06-28

~~DEO ATTACHED~~

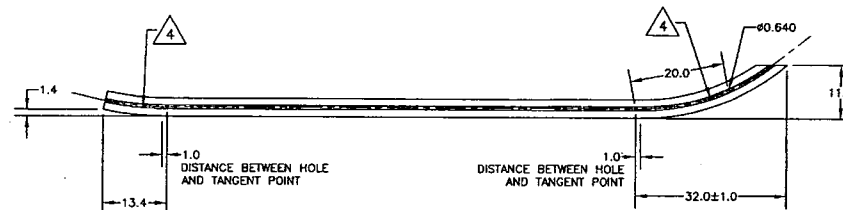
DETAIL C
SCALE 5:24



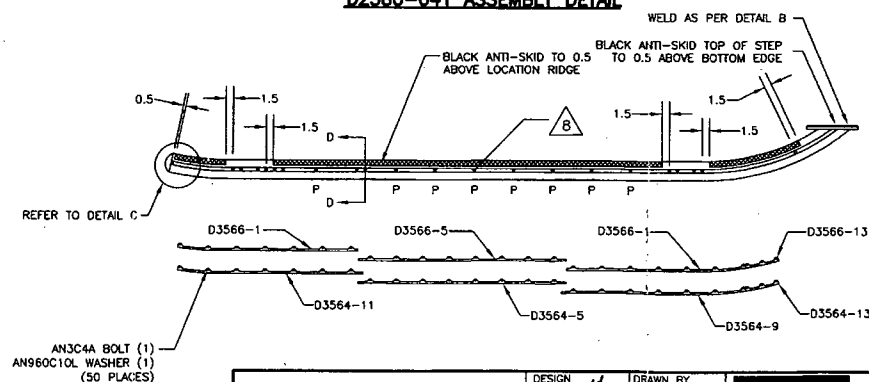
SECTION D-D
SCALE 5:24



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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APPROVED

DART

DART AEROSPACE LTD.
HAVERSBURY, ONTARIO, CANADA

REV. C

SHEET 2 OF 3

SCALE

1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

RELEASED
07-06-28

~~DEO ATTACHED~~

RMV CP 0.06.30

DETAIL G
SCALE 5:24

AN3-5A BOLT (1)
AN960JD10L WASHER (1)
(2 PLACES)

D2855 CAP—

SEAL WITH
SIKAFLEX-241/-291

— SEE NOTE ii)

940

SECTION H-H
SCALE 5:24

D2579 SPACER.

D2596 WEB (REF)

5 ALS7-1032-130 (REF)
(TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

[illegible]

D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)

[illegible]

D2580-045 ASSEMBLY DETAIL

WELD AS PER DETAIL

—BLACK ANTI-SKID TO 0.
ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP
5. TO 0.5 ABOVE BOTTOM EDGE

REFER TO

NO C'BOFE

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

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DESIGN

CHECKED *ml*

DATE _____

07.02.27

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DRAWING NC

02580

TITLE

205 SKIDTUBE ASSEMBLY

SHEET 1 OF 1

SHEET 3 OF 3

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Linda Lacelle

From: dshepherd@dartaero.com
Sent: April 18, 2011 11:36 AM
To: Linda Lacelle; Mike Petsche
Cc: Bill Beckett; 'Chris Provencal'; 'Eric Charbonneau'
Subject: Re: Alum. Solution Anneal - swaging

Makes sense to me ... We don't want to get caught short ... Make sure that if we do this, they are ident the old CHG number.

David

Sent from my BlackBerry device on the Rogers Wireless Network

From: "Linda Lacelle" <llacelle@dartaero.com>
Date: Mon, 18 Apr 2011 11:21:10 -0400
To: 'Mike Petsche' <mpetsche@dartaero.com>; <dshepherd@dartaero.com>
Cc: 'Bill Beckett' <bbeckett@dartaero.com>; 'Chris Provencal' <cprovencal@dartaero.com>; 'Eric Charbonneau' <echarbonneau@dartaero.com>
Subject: RE: Alum. Solution Anneal - swaging

I am ready to weld some up, I don't want to get into trouble with L/T's on these, any objections??

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: April 18, 2011 10:42 AM
To: 'Linda Lacelle'; dshepherd@dartaero.com
Cc: 'Bill Beckett'; 'Chris Provencal'; 'Eric Charbonneau'
Subject: RE: Alum. Solution Anneal - swaging

Well I'm not sure what to say.

It is my understanding that the swaging will still make sense even with the extra hoops we need to jump through if there is still uncertainty on the delivery of the material, we CAN still weld them if we need to.

And while this might be less than "world class", couldn't we take some of our tubing that we have in stock and with the welder to knock down the temper a little? Ground clamp on one end, torch on the other.....BZZZZZZZ

(I'm only sort of joking.....because I bet it would work)

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: April 18, 2011 9:44 AM
To: dshepherd@dartaero.com; 'Mike Petsche'
Cc: Bill Beckett; Chris Provencal; Eric Charbonneau
Subject: RE: Alum. Solution Anneal - swaging
Importance: High

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

NO. 262

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: B 71946
Part number: D205 634 041
Description: 205
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Salvador Date of Test Coupon 11-08-11
Welder Barclay Elliott Date of Test Coupon 11-08-11

The above named individual is qualified in accordance with AWS D17.1.2001 to weld